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D2435

Job Sheet 214147



Part No: D2435

Job Qty: 12 pcs

DAS
21
9-89

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/20

Job Tracking No:

Due Date: 11/13/20

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	Waterjet - Omax - 1	12 pcs	11/12/20	11/12/20	0.17	2.00	Waterjet - Omax	20/10/20
130	HAAS 4 Axis - B4B	12 pcs	11/13/20	11/13/20	1.00	12.17	HAAS - 1 - B4B	
							HAAS - 2 - B4B	20-11-29
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
150	QC 8	12 pcs	11/13/20	11/13/20	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	

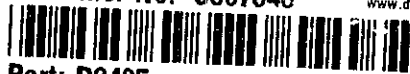
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
151 Packaging 3-1 - Stock - B4B	12 pcs	11/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	DEC 02 2020
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	12 pcs	11/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DEC 02 2020
				QC 21 - SA - 9	DAS
				QC 21 - SA - 77	21
				QC 21 - SA - 28	9-89
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) CUT BLANK AS PER FILE D2435 Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435 150 - (QC8- Inspect parts - second check) 151 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	38.4000 sf (3.2 ea)	120-Waterjet - Omax - 1		5228711 5235828

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Omax - 1	MUHMWB10	38	541	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053	
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470	
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170	
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220	
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240	
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	

Plex 10/19/20 3:05 PM dart.lacelle.linda



Container No: S307346



Part: D2435

Job No: 214147

Serial No/Batch: S307346

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/20/20

DART AEROSPACE LTD		Work Order: 214147
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063x45°	✓		Vernier	DIP-05
B 5.500	+/-0.030	5.500	✓		"	"
C 0.200	+/-0.030	0.187	✓		Depth Gage	DIP-04
D R0.250	+/-0.030	0.250	✓		R. Gage	REF
E 0.250	+/-0.010	0.256	✓		Vernier	DIP-05
F 0.625	+/-0.030	0.640	✓		"	"
G 0.25 x 45°	+/-0.030	0.250x45°	✓		"	"
H 0.375	+/-0.010	0.380	✓		"	"
I 19.000	+/-0.030	19.000	✓		Tape	REF
J 0.950	+0.030/-0.010	0.963	✓		Vernier	DIP-05
K Ø0.260	+0.005/-0.000	0.260	✓		"	"
L Ø0.930	+/-0.030	0.930	✓		"	"
M 0.30	+0.030/-0.000	0.310	✓		Depth Gage	DIP-04
N 0.375	+/-0.030	0.377	✓		Vernier	DIP-05
O 7.375	+/-0.030	7.375	✓		"	"
P 4.250	+/-0.010	4.250	✓		"	"
Q 2.000	+/-0.030	2.020	✓		"	"
R 9.000	+/-0.010	9.000	✓		"	"
S 15.750	+/-0.030	15.750	✓		Tape	REF

Measured by: DIP
Date: 20-11-28

Audited by: DAS 529-89
Date: 20/12/01

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	